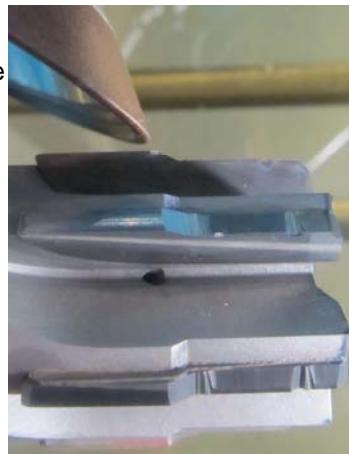


## Stepreamer Ø38 Z6

A15-010

The reamer Application A15 of Quinto5 allows easily to resharpen multistep reamers. The angle and position of a chamfer or step can be defined on three points. Beside those points a additional chamfer can be added to create a smooth connection on the tool-backside from the biggest diameter to the shaft-diameter. The approach of the wheel can be adjusted to the geometry to allow acces in difficult geometries. For each chamfer 3 clearance angles can be defined.



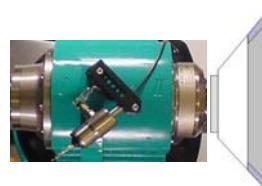
### 1. Cycletime for Resharpening

Workpiece:	Ø 38 mm, Z 6, Length of cutting edge 35 mm, Helix 0° Material CARBIDE				
Operations	Probe	End 1	Chamfer	Chamfer	Chamfer
Feed [mm/Min]	2000	250	300	300	300
Power [kW]		1	1	1	1
Cutting speed [m/s]		24	24	24	24
Used wheels		1	1	1	1
Grinding time [s]	25	59	33	59	59
Total cycle time	3 Min 55				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	12V9 Ø125 D64
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### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: LLU 9.2.12

[www.schneeberger.ch](http://www.schneeberger.ch)

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